

Work Order ID 158206

Wednesday, March 15, 2017 12:36:14 PM

158206

Page 1

Item ID: D4366-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Run-on Landing Wearplate Aft
Start Date: 3/16/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/22/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED
Approvals: Process Plan:  Date: MAR 15 2017 Run Start ***NR1***
QC: Date: Tooling: Date: Stop ***NR2***
SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4366	C

110

0.00

110

Large Fab

Memo

1.70

Large Fab

- Weld D4367-043 to wearplate by positioning holes together as per dwg D4366

304 S.S. Welding Rod

BATCH #: M134442

2-Transfer drill holes in bar and cut extra material on bar if necessary

1 ea 17-3-17

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

① 17-03-17 PD

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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158206

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N900040100

NS1

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

0.00

Memo

0.02

① 17-03-17 10

0.00

Memo

0.09

1- After finish, coat entire top (concave) surface as per note 9 dwg D4366.
TEXTURED COATING B#: 136470

1

DAS
41
9-80

MAR 17 7 29 AM '77

0.00

Memo

0.02

1

DAS
38
9-89

MAR 20 2017

DQA: _____ Date: _____



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Work Order ID 158206

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158206

Page 3

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Revision ID: Stop ***NS2***
Item Name: Run-on Landing Wearplate Aft
Start Date: 3/16/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/22/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>FR-002</u>	0.00							
160									
Packaging	Memo	0.01							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							
Quality Control									

1x of 15/03/2017

17/3/21

MAR 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, March 15, 2017 2:50:31 PM

Page 1

Work Order ID: 158206

158206

Parent Item: D4366-043

D4366-043

Parent Item Name: Run-on Landing Wearplate Aft

Start Date: 3/16/2017

Required Date: 3/22/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.12 new issue DD verf:EC IPP REV:B
14.02.06 DWG PB1 DD VERF:JLM IPP REV:C 14.04.22
DWG B DD VERF:JLM IPP REV:E 16.06.17 DWG.C
DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4366-3

Manufactured

No

110

Each

7.0000

1

1

D4366-3

Plate

**

EL 17-3-17

Location

Loc Qty

Loc Code

WA002

7

12781

7

D4367-043

Manufactured

No

110

Each

4.0000

1

1

D4367-043

Bar Weldment

**

EL 17-3-17

Location

Loc Qty

Loc Code

WA001

4

151534

4

2

DQA: _____ Date: _____

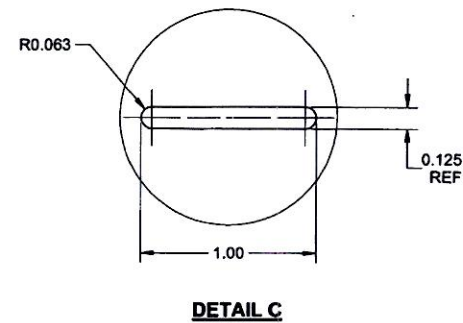
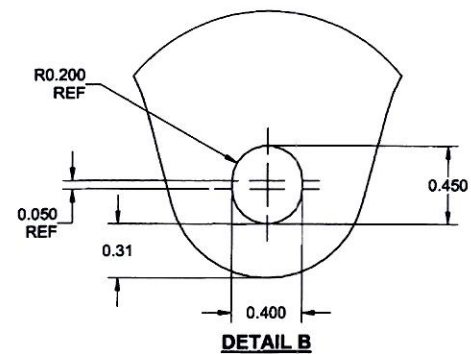
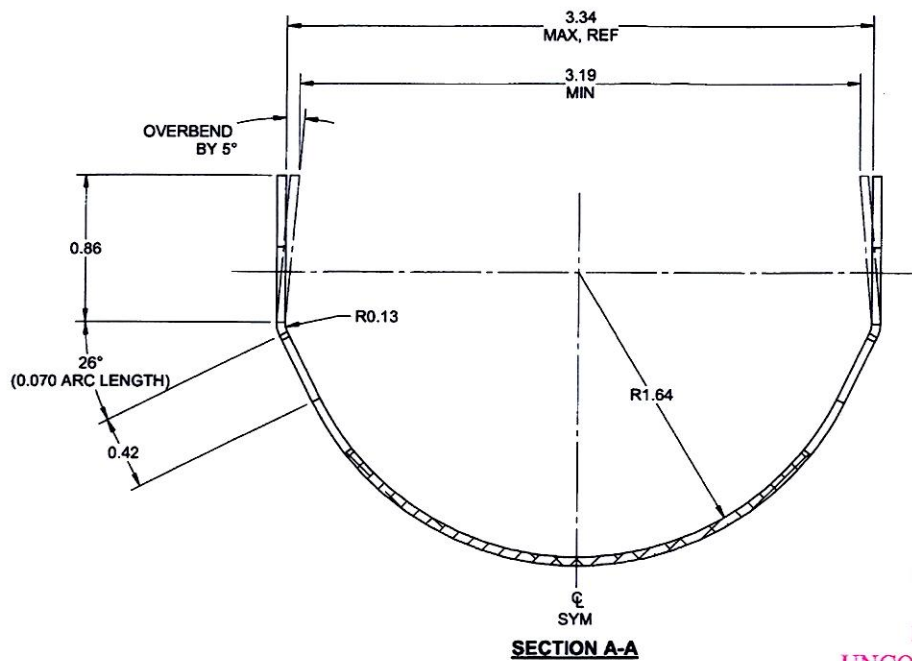


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Description Work Order Deviation				Disposition				Completed By																																																													
Root Cause				FAULT CATEGORY																																																																	
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WITHOUT NOTICE
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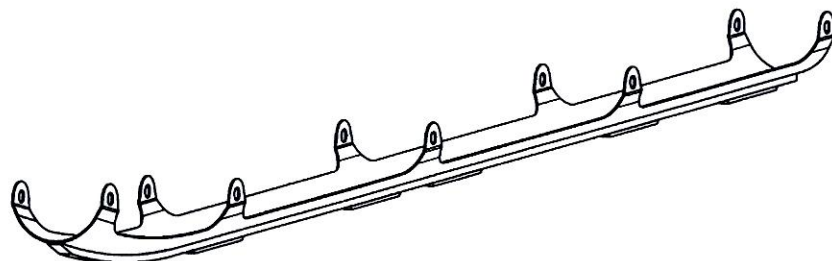
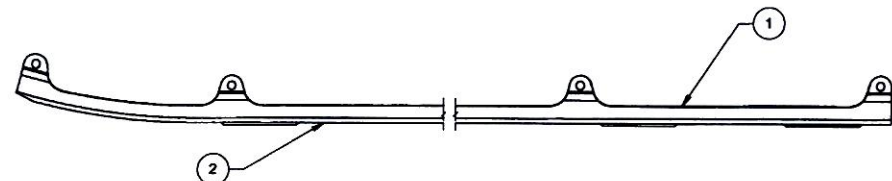
MAR 15 2017

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2016-06-16

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DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4366	SHEET 5 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.04.11	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4366-041	WEARPLATE ASSY
1	1	D4366-1	PLATE
2	1	D4367-041	BAR



D4366-041 FWD WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4366-041" PER QSI 044 6.1
- 7) WEIGHT: D4366-041 = 5.30 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES THRU D4367-041 BAR WELDMENT FROM D4366-1 WEARPLATE AFTER WELDING

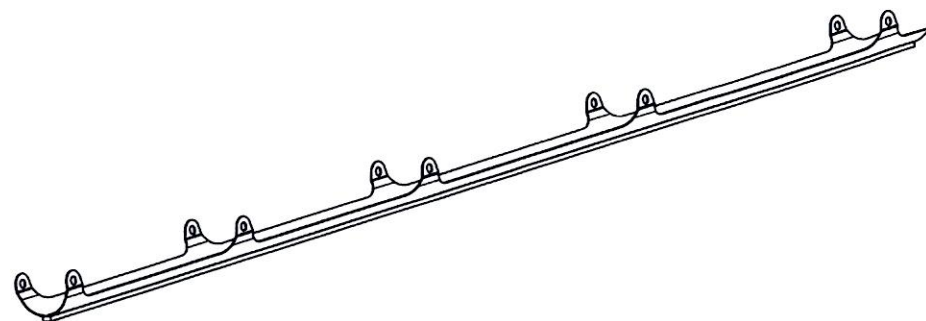
C	D4367-041 WAS D4367-1, D4367-043 WAS D4367-3, REMOVE HARDCOAT WELD (MOVED TO D4367), UPDATE TOLERANCES, PART WEIGHTS (SH 384), RELABELED VIEWS, UPDATE NOTES	DB	16.04.11
B	TEXTURED COATING WAS ROCKGUARD 4714 (BOM TABLE), REVISE NOTE 10 (SH 2).	DB	13.11.04
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	DB		
CHECKED	ML	DRAWING NO. D4366	
MFG. APPR.	DD		
APPROVED	WM	TITLE WEARPLATE ASSY	
DE APPR.	DS		
DATE	16.04.11	REV. C SHEET 1 OF 5 SCALE NTS	

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2016-06-16
E2116-574

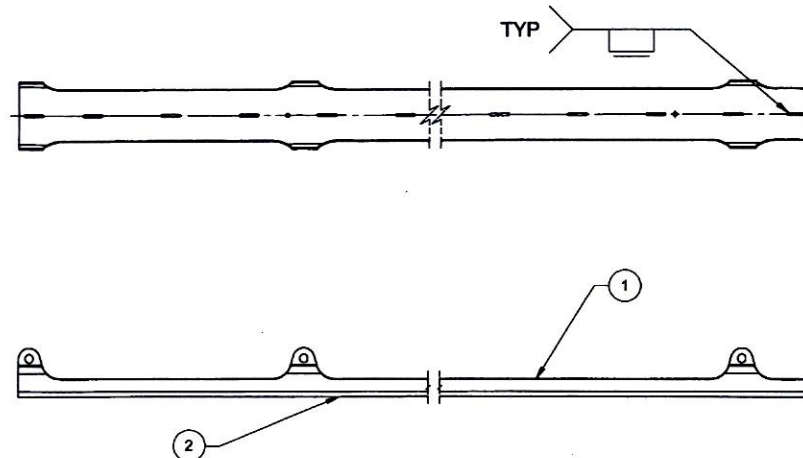
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4366-043	WEARPLATE ASSY
1	1	D4366-3	PLATE
2	1	D4367-043	BAR WELDMENT



D4366-043 AFT WEARPLATE ASSY



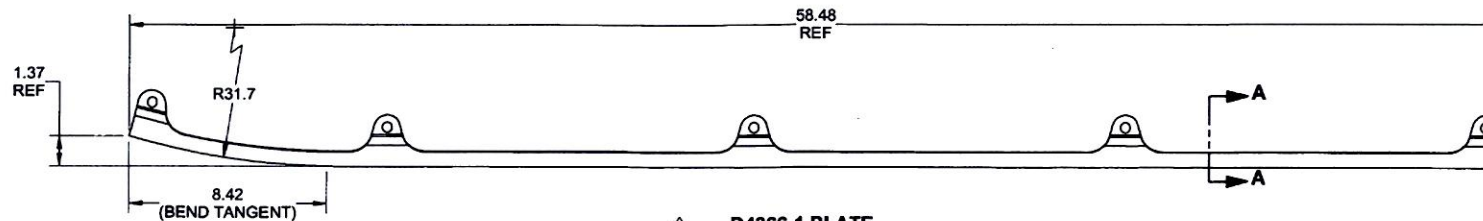
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4366-043" PER QSI 044 6.1
- 7) WEIGHT: D4366-043 = 6.56 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES THRU D4367-043 BAR WELDMENT FROM D4366-3 WEARPLATE AFTER WELDING

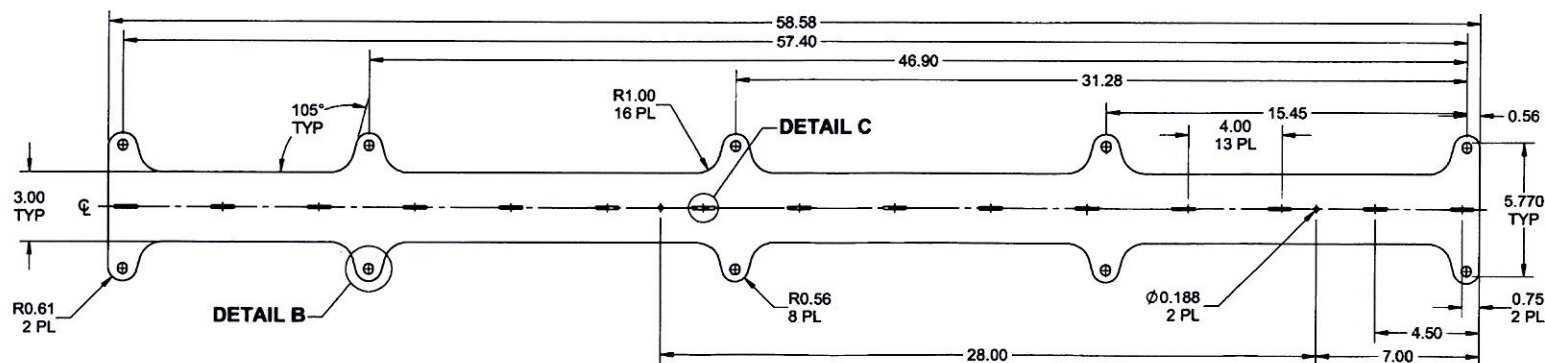
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CHECKED	ML	DRAWING NO.	REV. C
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DE APPR.	DS	WEARPLATE ASSY	NTS
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D4366-1 PLATE
(MAKE FROM D4366-1F)



D4366-1F PLATE
(FLAT PATTERN)

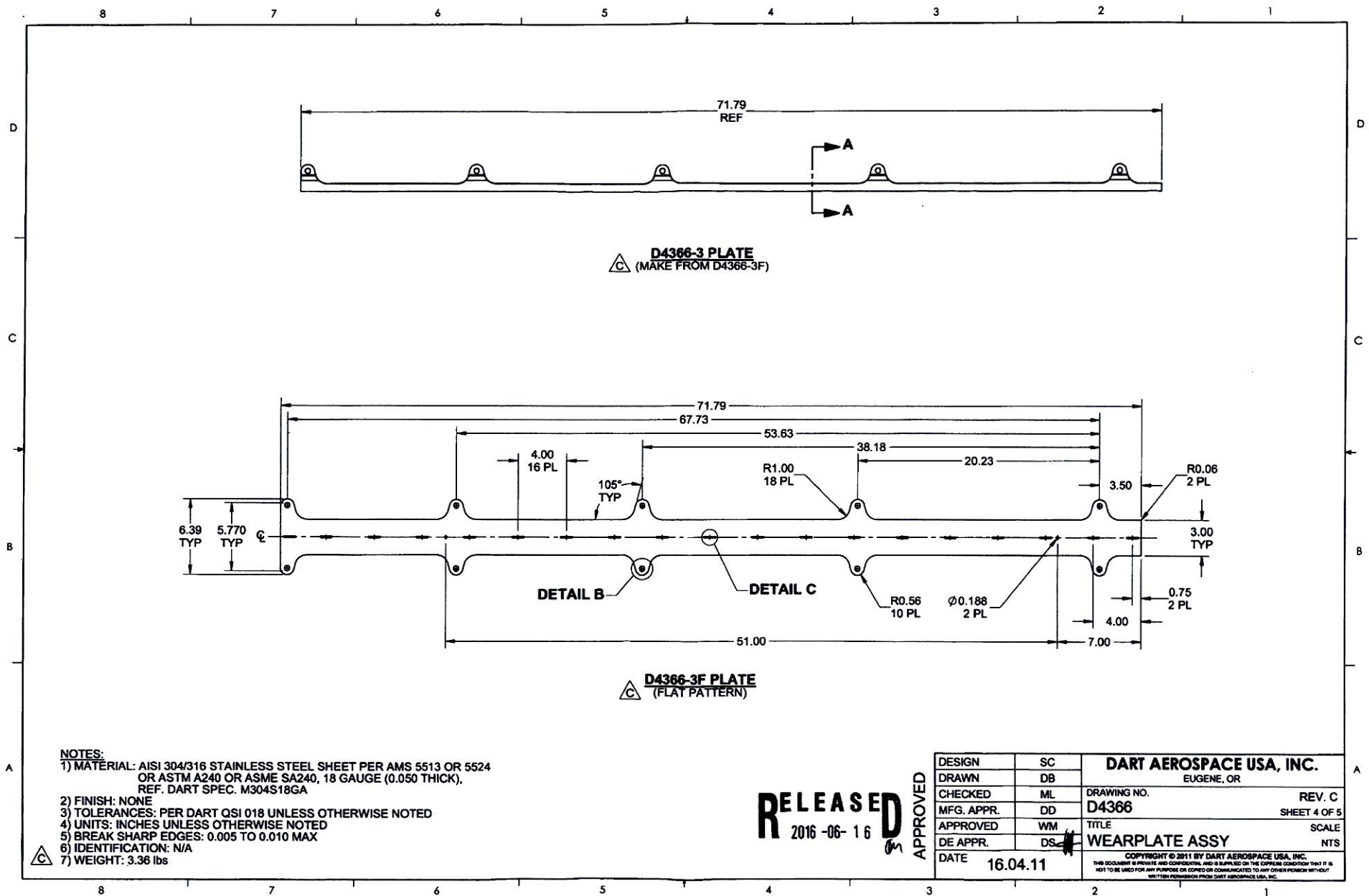
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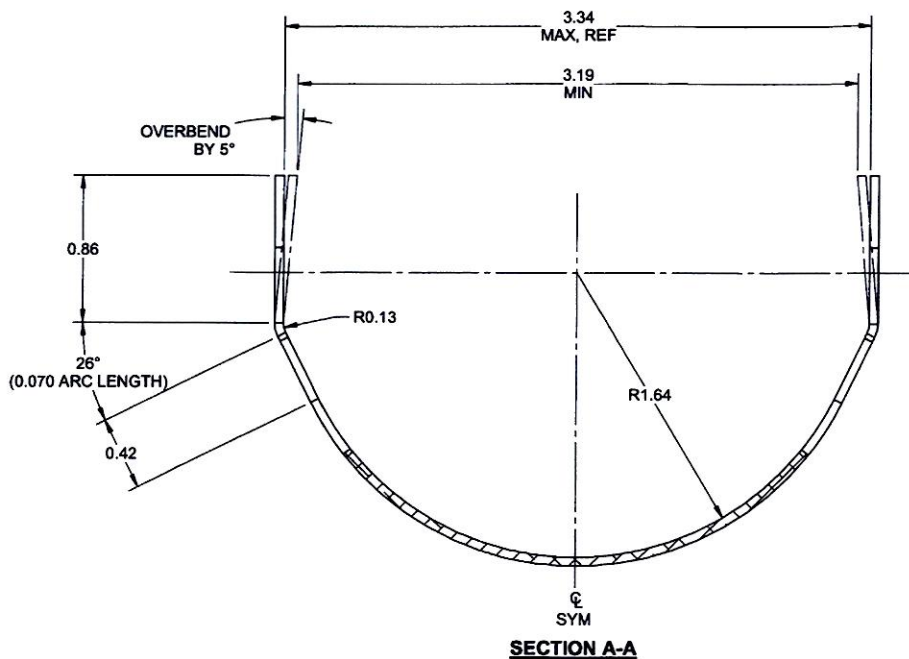
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.79 lbs

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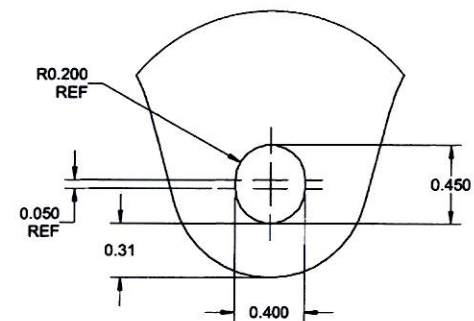
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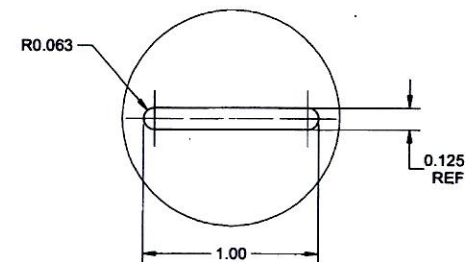




SECTION A-A



DETAIL B



DETAIL C

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